

RUSH!

Work Order ID 64327



Page 1

December 2, 2010 11:44:23 AM

Item ID: D3215-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Webbing Tidy

Start Date: 12/02/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/12/02

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3215	Rev D								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3215 (D3215-3A)

☐ Dwg Rev: D ☐ ProgRev: D ☐ 2-Deburr if necessary☐ 3-Identify as D3215-3A

WB10-12-2

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

WB10-12-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/12/03

(4/2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Cut D3215-3B (2.130" x 0.530") as per dwg D3215□2-Deburr□3-Identify as D3215-3B								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Form D3215-3A as per Dwg D3215								

E/S 10/12/06 (12)

SB 10/12/06

(12)

SB 10/12/06

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooing:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

D3215-3 B → S 10/12/06 (12)

QC

Memo

0.00

D3215-3A → S 10/12/06 (12)

Quality Control

S 10/12/06

(12)

170

Large Fab

0.00

Large Fab

Memo

0.00

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004 □ A/R AL ROD BATCH: M112860 □ Identify as D3215-3 □ Grind flush

lpl 10-12-06

(12x)

180

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(12)

8

FE 10-12-06

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Start Date: 12/02/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

12/12/10

H2

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BL 10-12-6

210

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M110588

START TIME:

3:40

OVEN TEMPERATURE:

320° FINISH TIME:

4:40

12 BL 10-12-6

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	\Rightarrow M	10/12/07		12	ϕ		
230 Packaging Packaging	Packaging Memo	0.00 0.00				CL	10/12/07	(X12)	
240 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					10/12/07		

CL 10/12/07

Picklist Print

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Page 1

Work Order ID: 64327

Parent Item: D3215-3

Parent Item Name: Webbing Tidy



Start Date: 12/02/10

Required Date: 12/06/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.01.06 New issue KJ/RF
IPP Rev:B Now on Waterjet 06-07-03 JLM
IPP rev C ecn 940 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040		Purchased	No			100	sf	19.3234	0.0258	0.050526			
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5052-H32 .040 Sheet

Location	Loc Qty	Loc Code
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MAT	16.3	
114488	16.3	
MAT23	3.0234	
109058	1.6234	
113123	1.4	

114488

12-10-12-2

12

M5052H32S.040		Purchased	No			130	sf	19.3234	0.0258	0.162947			
---------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



5052-H32 .040 Sheet

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	16.3	
114488	16.3	
MAT23	3.0234	
109058	1.6234	
113123	1.4	

12/10/12/06

114488 12x
1101875

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

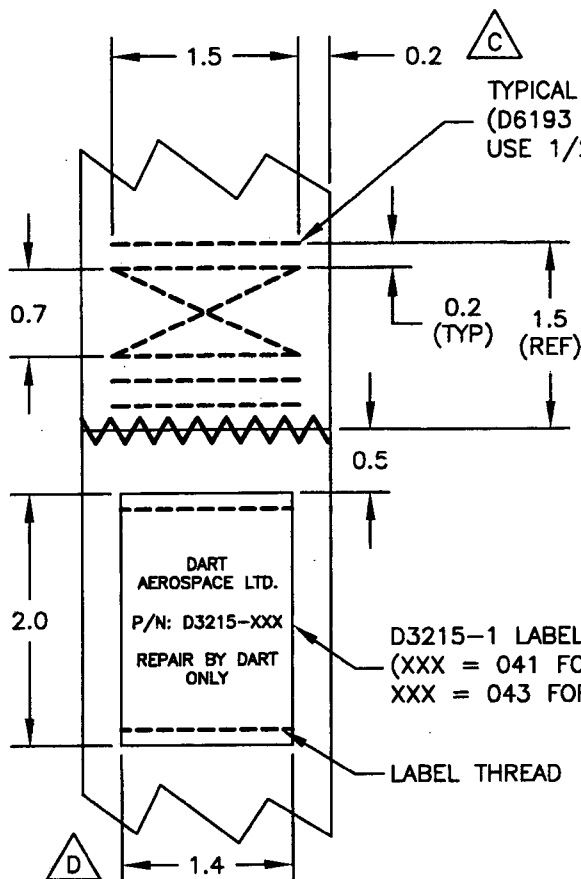
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27	TITLE HARNESS ASSEMBLY		SCALE 3:2

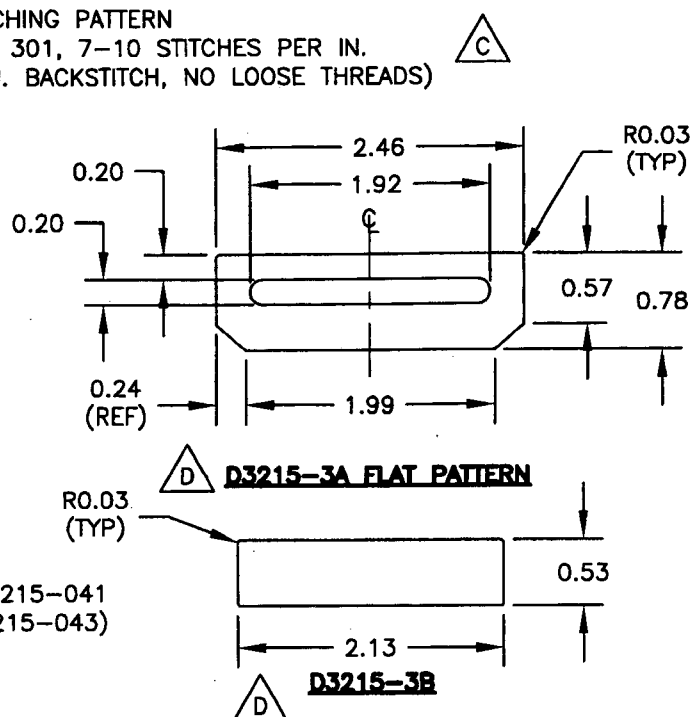
**VIEW A-A****D3215-1 LABEL:**

- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

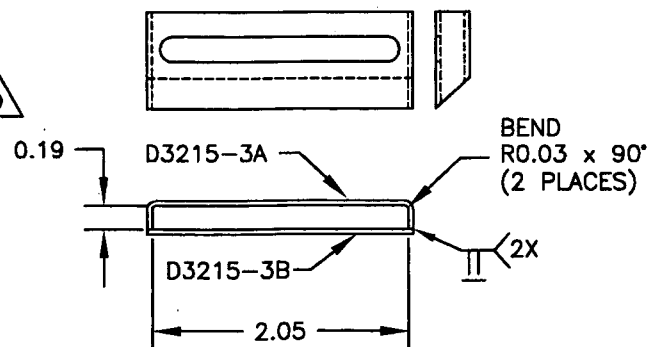
CD10112102
W10:64327

RELEASED*07.06 07***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

**D3215-3A/-3B NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 WEBBING TIDY****D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3

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